

0350-591-214

Work Order ID 123251

\*123251\*

Page 1

August-05-14 3:09:32 PM

REV-A

Item ID: D350-591-214

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step™ RH

Start Date: 8/05/14 Start Qty: 4.00 \*4\*

Cust Item ID:

Required Date: 8/15/14 Req'd Qty: 4.00 \*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3078

A

DSI 9472

A

100

Document Control

0.00

\*100\*

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-214 CHG003

DAS

38

9-89

14-9-3

110

Large Fab

0.00

\*110\*

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078  
 2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.  
 3-Deburr

4 14-8-13 DMC

# Work Order ID 123251

**\*123251\***

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Page 2

Item ID: D350-591-214

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Heli-Access-Step™ RH

Stop

**\*NS2\***

Start Date: 8/05/14 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 8/15/14 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Memo

0.00

Quality Control

4 0 14.08.13

130

Large Fab

0.00

**\*130\***

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY  
2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078  
A/RAluminum Rod 125091  
3-Grind End Plate flush

4 0 DME 14.08.14

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*140\***

QC

Memo

0.00

Quality Control

4 AUG 20 2014 DAS 24 9-59

# Work Order ID 123251

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**\*123251\***

Page 3

Item ID: D350-591-214

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Heli-Access-Step™ RH

Stop

**\*NS2\***

Start Date: 8/05/14

Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 8/15/14

Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

4 AUG 28 2014

DAS  
24  
9-89

160

Chemical Conversion Coat per QSI005 4.1

0.00

**\*160\***

HandFinish

Memo

0.00

Hand Finishing

4 x 14-08-20 DMC

170

QC3- Inspect Part Finish

0.00

**\*170\***

QC

Memo

0.00

Quality Control

4 14-8-20 DAS 34 9-89

# Work Order ID 123251

**\*123251\***

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Page 4

Item ID: D350-591-214 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Heli-Access-Step™ RH  
 Start Date: 8/05/14 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 8/15/14 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Large Fab	0.00				4	0	DMC	14-08-21
<b>*200*</b>									
Large Fab	Memo	0.00							
Large Fab	1- Rivet Leg Assembly as per Dwg D3078. DMC 14-8-20								
	2-Bevel Aft end for welding								
	3-Inspect for foreign object as per QSI 024								
	4-Weld Aft End Plate as per QSI004 & Dwg D3078								
	A/R Aluminum Rod 125091								
	5-Grind End Plate flush								
210	QC10- Inspect visual per QSI004- ground welds	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control									

4 AUG 21 2014 DAS 24 9-59

# Work Order ID 123251

**\*123251\***

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Item ID: D350-591-214 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Heli-Access-Step™ RH  
 Start Date: 8/05/14 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 8/15/14 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC5- Inspect part completeness to step on W/O	0.00				4		AUG 21 2014	DAS 24 9-89
<b>*220*</b>									
QC	Memo	0.00							
Quality Control									
230	Chemical Conversion Coat per QSI005 4.1	0.00						AUG 21 2014	DAS 24 9-89
<b>*230*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*240*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 12:00 OVEN TEMPERATURE: 350° FINISH TIME: 12:30								

*Handwritten signature*  
 AUG 21 2014  
*Handwritten signature*

*Handwritten signature*  
 14-8-25  
 24 9-89

# Work Order ID 123251

**\*123251\***

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Item ID: D350-591-214

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Heli-Access-Step™ RH

Stop **\*NS2\***

Start Date: 8/05/14 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 8/15/14 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Wing Walk as per dwg QSI005 4.4 Batch	1.129							
<b>*250*</b>									
HandFinish	Memo	0.00				x4124	1	11	14/08/29
Hand Finishing									
260	QC3- Inspect Part Finish	0.00							
<b>*260*</b>									
QC	Memo	0.00							
Quality Control									
270	Pick Kit	0.00							
<b>*270*</b>									
Packaging	Memo	0.00							
Packaging									

① 14-08-29  
RH

DAS 32 9-89  
14/8/2 ④ ⑤ ⑥ 9-89

# Work Order ID 123251

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Item ID: D350-591-214 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Heli-Access-Step™ RH  
 Start Date: 8/05/14 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 8/15/14 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC4- 100% Inspect kits for completeness	0.00				4			DAS 38 9-89 14-9-3
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									
290	Packaging	0.00							DAS 06 9-89 SEP 03 2014
<b>*290*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-591-214								
	Location: 039								
	PPP Rev: _____								
300	QC21- Final Inspection - Work Order Release	0.00							
<b>*300*</b>									
QC	Memo	0.00							
Quality Control									

MLJ 14-09-04  
 MLJ 1409-04

# Picklist Print

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Work Order ID: 123251

**\*123251\***

Parent Item: D350-591-214

**\*D350-591-214\***

Parent Item Name: Heli-Access-Step™ RH

Start Date: 8/05/14

Required Date: 8/15/14

Start Qty: 4.00

Required Qty: 4.00

## Comments:

IPP Rev:B05.10.14Modified step 10KJ/EC

IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM

IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D

10.11.15 update qty on AN4-11A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			110	Each	163.0000	0.5	2			
<b>*D2622-120C*</b>									<b>**</b>				
Step Extrusion													

Location	Loc Qty	Loc Code
HALL	152	
109575	32	
119621	120	
WA003	11	
101765	1	
<u>115141</u>	10	

D3063-1

Manufactured No

130

Each

86.0000

1

4

**\*D3063-1\***

Support

**\*\***

Location	Loc Qty	Loc Code
WA003	86	
113631	25	
114976	41	
119780	20	

14-8-13-DMC

14.08.13

4



# Picklist Print

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Page 2

Work Order ID: 123251

**\*123251\***

Parent Item: D350-591-214

**\*D350-591-214\***

Parent Item Name: Heli-Access-Step™ RH

Start Date: 8/05/14

Required Date: 8/15/14

Start Qty: 4.00

Required Qty: 4.00

D3067-1

Manufactured No

130

Each

462.0000

1

4

**\*D3067-1\***

End Plate

**\*\***

*14-08-13*

Location

Loc Qty

Loc Code

WA003

462

101785

67

102686

14

116323

6

117776

225

119290

150

*4*

D3066-1

Manufactured No

200

Each

222.0000

2

8

**\*D3066-1\***

Spacer

**\*\***

*14-8-20 DMC*

Location

Loc Qty

Loc Code

WA003

222

106302

7

115867

52

115868

52

115869

60

117799

51

*89*

MS20600-AD4W4

Purchased No

200

Each

3,364.000

16

64

**\*MS20600-AD4W4\***

Rivets

**\*\***

*14-8-20 DMC*

Location

Loc Qty

Loc Code

ST310

3364

125577

215

M128429

149

M128899

3000

*641*

August-05-14 3:09:30 PM

Shop Packet Print

Page 2

# Picklist Print

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Page 3

Work Order ID: 123251

**\*123251\***

Parent Item: D350-591-214

**\*D350-591-214\***

Parent Item Name: Heli-Access-Step™ RH

Start Date: 8/05/14

Required Date: 8/15/14

Start Qty: 4.00

Required Qty: 4.00

D3065-041

Manufactured No

200 Each

20.0000 1 4

**\*D3065-041\***

Step Leg Assembly

\*\*

DMC 14-8-20

Location

Loc Qty

Loc Code

WA003

B115697

20

102830

6

109447

2

113075

2

115696

10

4

D3067-1

Manufactured No

200 Each

462.0000 1 4

**\*D3067-1\***

End Plate

\*\*

14-08-21

Location

Loc Qty

Loc Code

WA003

462

101785

67

102686

14

116323

6

117776

225

119290

150

4

AN4-16A

Purchased No

270 Each

220.0000 4 16

**\*AN4-16A\***

Bolt

DAS  
38  
9-89

\*\*

DAS  
32  
9-89

DAS  
32  
9-89

14/9/12

Location

Loc Qty

Loc Code

FG

5

121541

5

ST343

100

M129590

100

ST357

27

M128324

19

M128978

8

ST515

88

M128813

88

M128813

August-05-14 3:09:30 PM

Shop Packet Print

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Page 4

Work Order ID: 123251

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step™ RH

**\*123251\***

**\*D350-591-214\***

Start Date: 8/05/14

Required Date: 8/15/14

Start Qty: 4.00

Required Qty: 4.00

D2732

Manufactured No

270 f

1,000.023 1 4

DAS  
32  
9-89

DAS  
06  
9-89

**\*D2732\***

Rubber Extrusion

DAS  
38  
9-89

\*\*

## Location

## Loc Qty

## Loc Code

ST415

1000.023710

107346

0.0237104

117118

1000

Cut 3.00" long, qty 4

AN3-35A

Purchased No

270 Each

171.0000 2 8

DAS  
32  
9-89

DAS  
06  
9-89

**\*AN3-35A\***

Bolt

DAS  
38  
9-89

\*\*

## Location

## Loc Qty

## Loc Code

FG

10

122800

10

ST348

160

m128634

10

m129706

50

m129934

100

ST352

1

m127460

1

AN4-11A

Purchased No

270 Each

414.0000 2 8

DAS  
32  
9-89

DAS  
06  
9-89

**\*AN4-11A\***

BOLT

DAS  
38  
9-89

\*\*

## Location

## Loc Qty

## Loc Code

FG

20

120731

20

ST356

182

M128362

182

ST514

212

M126333

5

M127376

58

M128769

149

M128769

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Page 5

Work Order ID: 123251

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step™ RH

**\*123251\***

**\*D350-591-214\***

Start Date: 8/05/14

Required Date: 8/15/14

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

270

Each

6,989.000

12

48

**\*NAS1149D0463J\***

WASHER

DAS  
38  
9-89

\*\*

DAS  
32  
9-89

DAS  
06  
9-89

Location

Loc Qty

Loc Code

CA

485

M129682

485

ST277

6504

16941

8

M126221

20

M127813

6

M127904

127

M128591

44

M128995

1500

M129390

4799

D2230-3

Manufactured

No

270

Each

482.0000

2

8

**\*D2230-3\***

Mounting Lug

DAS  
38  
9-89

\*\*

DAS  
32  
9-89

DAS  
06  
9-89

Location

Loc Qty

Loc Code

FG

7

109344

4

89045

3

ST519

475

108668

1

109344

2

114151

1

114921

6

115583

146

116378

159

116379

160

1123390

116379

# Picklist Print

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Work Order ID: 123251

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step™ RH

**\*123251\***

**\*D350-591-214\***

Start Date: 8/05/14

Required Date: 8/15/14

Start Qty: 4.00

Required Qty: 4.00

D2856-400

Manufactured No

270 f

265.8000

0.6 3  
\*\*

DAS  
32  
9-89

DAS  
06  
9-89

**\*D2856-400\***

Abrasion Strip 4" Wide (Per Foot)

DAS  
38  
9-89

Location

Loc Qty

Loc Code

ST426

265.8

112524

49.8

117887

216

117887

DAS  
06  
9-89

cut 7.20" long, qty 1

MS21042L3

Purchased

No

270 Each

4,442.000

2 8  
\*\*

DAS  
32  
9-89

14/9/2 (4)

**\*MS21042L3\***

Nut

DAS  
38  
9-89

Location

Loc Qty

Loc Code

ST307

4442

123900

955

M126333

2

M127410

11

M127831

41

M128401

42

M128754

3391

M128704

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Work Order ID: 123251

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step™ RH

**\*123251\***

**\*D350-591-214\***

Start Date: 8/05/14

Required Date: 8/15/14

Start Qty: 4.00

Required Qty: 4.00

AN4-13A

Purchased

No

270

Each

765.0000

4 16

**\*AN4-13A\***

DAS  
38  
9-89

Bolt

\*\*

DAS  
32  
9-89

DAS  
36  
9-89

Location

Loc Qty

Loc Code

CA

2

m129682

2

FG

20

122808

20

GA

14

m125709

14

ST515

729

m127432

36

m127817

22

m128739

671

D2230-1

Manufactured

No

270

Each

640.0000

2 8

**\*D2230-1\***

DAS  
38  
9-89

Mounting Lug

\*\*

DAS  
32  
9-89

14/9/2 (14)

Location

Loc Qty

Loc Code

FG

4

84136

4

ST519

636

101834

1

110834

16

113437

124

115306

95

116380

160

116381

160

116382

80

113437

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Work Order ID: 123251

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step™ RH

**\*123251\***

**\*D350-591-214\***

Start Date: 8/05/14

Required Date: 8/15/14

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

270

Each

5,442.000

24

DAS  
32  
9-89

**\*MS21042L4\***

Locknut

DAS  
38  
9-89

Location

Loc Qty

Loc Code

ST307

5442

126275

5

m126015

12

m126275

27

m127255

63

m127376

11

m127813

891

m128300

80

m128798

1853

m129472

1000

m129934

1500

m128798

DAS  
06  
9-89

NAS1149D0363J

Purchased

No

270

Each

2,558.000

16

DAS  
32  
9-89

**\*NAS1149D0363J\***

Washer

DAS  
38  
9-89

Location

Loc Qty

Loc Code

GA

23

124392

23

ST276

8

m123441

8

ST510a

2527

m126319

2

m128429

2525

m128429

4/18/14 (4)



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3078</b>	REV. A SHEET 1 OF 2
DATE <b>02.09.11</b>		TITLE <b>STEP ASSEMBLY, HI SHORT</b> SCALE NTS	
A	02.09.11	NEW ISSUE	

**RELEASED**  
02.09.20 *#*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

**GENERAL NOTES:**

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

*020925*

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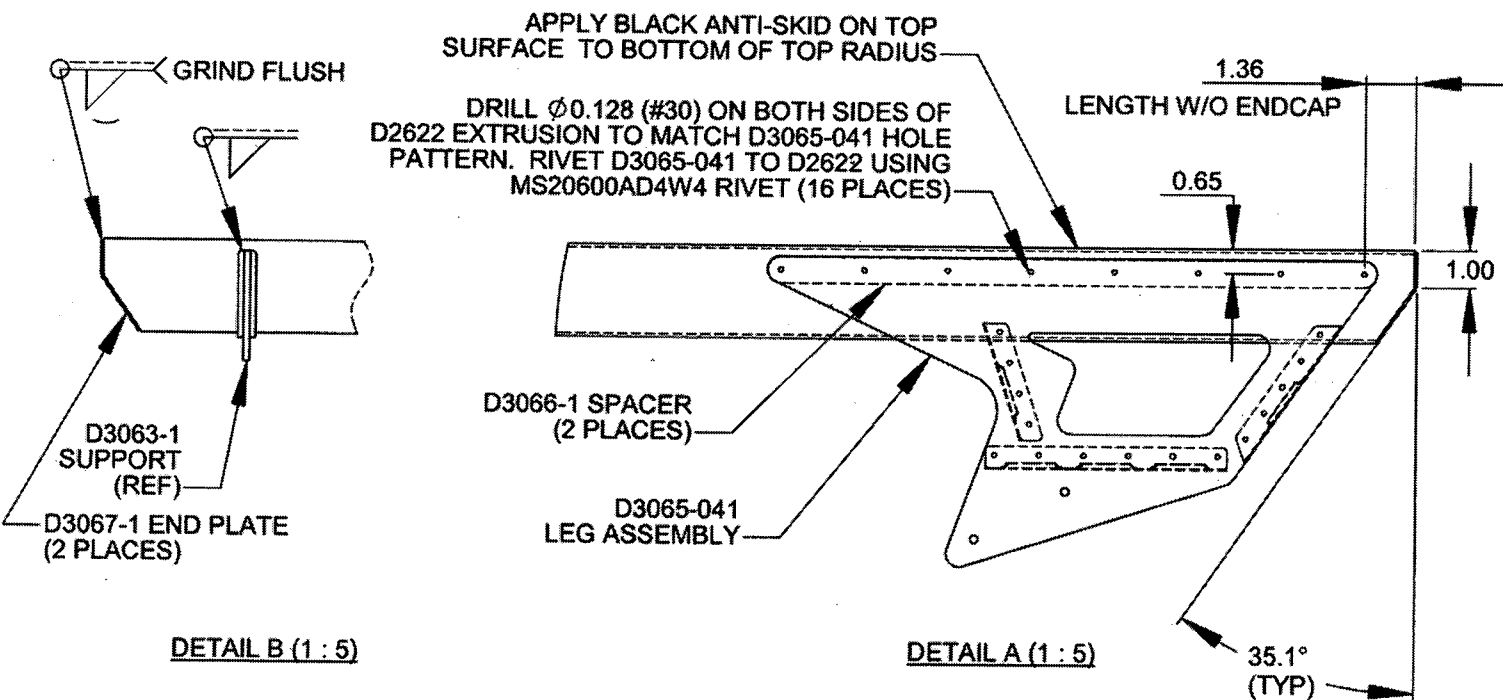
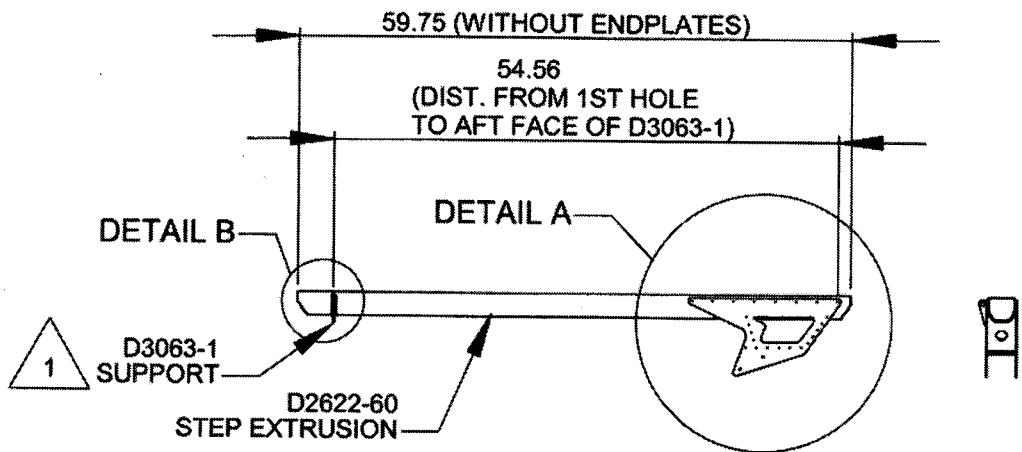
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